

5/08

7.08 4.28

DART AEROSPACE LTD	Work Order:	22182
Description: Saddle Spacer	Part Number:	D2876
Drawing: D2876 Rev.A	Qty:	120 160 155
		Multiples of 40

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	PH	05.01.14	120
2	METAL	1 blank makes 4 parts Blank: 7.00" x 4.25" (+0.030" - 0.000") Material: 5052-H32/H34 (QQ-A-250/8) 0.100" Thick	CP	05.01.17	160 30
3	HAAS	Machine per folio D2876	B	05.01.17	160
4	QC	Inspect Level 2	EC	05.01.18	160
5	QC	Inspect Level 8	En	05.01.18	160
6	METAL	Tumble	EC	05.01.18	160
7	METAL	Deburr any rough edges after tumbling	SB	05.01.24	160
8	METAL	Acid etch and Alodine as per QSI 005 4.1	JR	05.01.24	155
9	QC	Inspect Level 7	ML	05.01.25	155
10	STORES	Identify and stock	JL	05.01.25	155
11	EXPEDITING	Close W/O Cost / part: 1.23 54C 05/01/20 (155)	PH	05.01.27	155

Rev	Date	Change	Revised By	Approved
A	99.10.12	New Issue	EC	
B	00.05.19	Added inspect level 8	EC	

RELEASED

EC 00.05.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

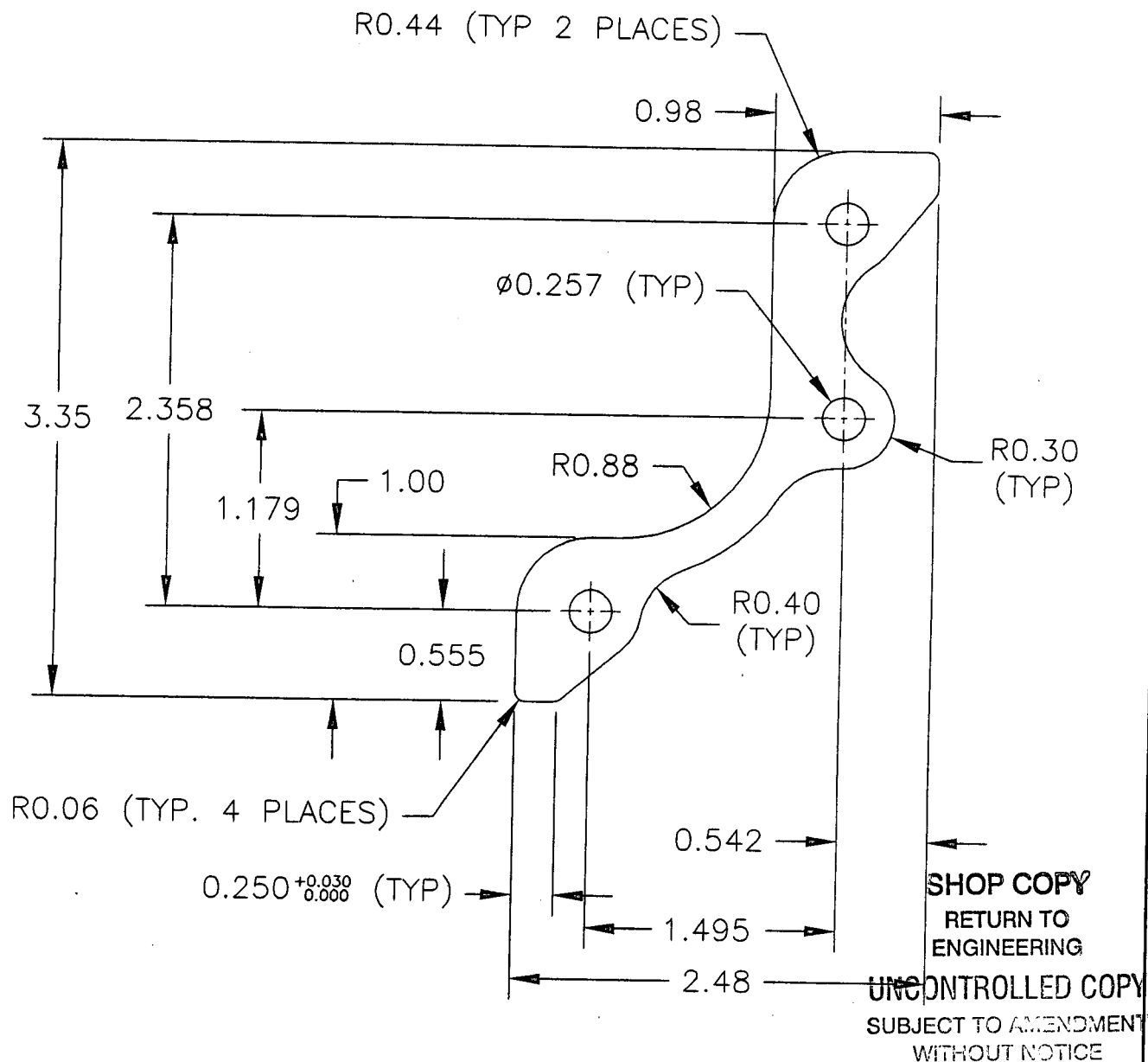
NCR: 22182		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.01.17	2	-10 scrap Unit sent to Lab - changed	<i>[Signature]</i> 05.01.17	- Replace & destroy	<i>[Signature]</i> 05.01.17	<i>[Signature]</i> 05.01.17	<i>[Signature]</i> 05.01.17	<i>[Signature]</i> 05.01.17

Part No: D2876 PAR #: NA Fault Category: Manuf/Misc DCA/NCR: Yes ☒ No ☐ DQA: [Signature] Date: 05/01/27
 NOTE: Date & initial all entries QA: N/C Closed: [Signature] Date: 05.01.27



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>\$</i>	DRAWING NO. D2876	REV. A SHEET 1 OF 1
DATE 99.02.23		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	

RELEASED
99.04.27 DS



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.100 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020

WORK ORDER
NO. 22182

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 12, 2005
01:18 pm

Work Order No : 0022182
Project Name : D2876
Project For : WK508
Work Order Type : Main
Main WO Number :
House Part Number : D2876
Description : Saddle Spacer
Manufactured : Yes
Amount Req'd : 120
Amount Done : 0
Start Date : 01-12-05
Est Finish Date : 02-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00